

Work Order ID 147924

Wednesday, June 22, 2016 8:37:21 AM

147924

Page 1

Item ID: D3220-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler Assembly

Stop

NS2

Start Date: 6/8/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3220

B

100

0.02

100

FLOW WATER JET

Waterjet

Memo

0.10

FLOW CNC Waterjet

1-Cut D3220-2 as per Dwg D3220

Dwg Rev: BProg Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

PR 2016/06/26

PR 2016/06/26

Work Order ID 147924

Wednesday, June 22, 2016 8:37:21 AM

147924

Page 3

Item ID: D3220-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 6/8/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.06				6			DL 16/06/30
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.01				6X			16/07/05 DAS 36 9-89
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.05				6X			16/07/05 DAS 36 9-89
Small Fab	Assemble D3220-042 doubler as per Dwg D3220								

Work Order ID 147924

Wednesday, June 22, 2016 8:37:21 AM

147924

Page 4

Item ID: D3220-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 6/8/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.01							DAS 38 9-89 JUL 06 2016
Quality Control									
190	Identify as per dwg & Stock Location: 51485	0.00							
190									
Packaging	Memo	0.01							6 DAS 9-89 JUL 07 2016
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.07							16/7/12 JF
Quality Control									

DAS
21
9-89 JUL 08 2016

Picklist Print

Wednesday, June 22, 2016 8:37:20 AM

Page 1

Work Order ID: 147924

147924

Parent Item: D3220-042

D3220-042

Parent Item Name: Doubler Assembly

Start Date: 6/8/2016

Required Date: 6/17/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

Purchased

No

100

sf

59.8000

0.6926

2.916210

M2024T3S 050

2024-T3 .050 sheet

PR 2016/06/26

Location

Loc Qty

Loc Code

MAT022

59.8

m131564

24.2

m134581

35.6

4.9

MS20426AD3-3

Purchased

No

170

Each

1,385.000

8

32

MS20426AD3-3

RIVET

16/07/05 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

462

M131624

462

ST312

923

M131624

923

48

MS21059L4

Purchased

No

170

Each

38.0000

4

16

MS21059L 4

Nutplate

16/07/05 DAS 36 9-89

Location

Loc Qty

Loc Code

ST301

38

m133483

4

m134474

9

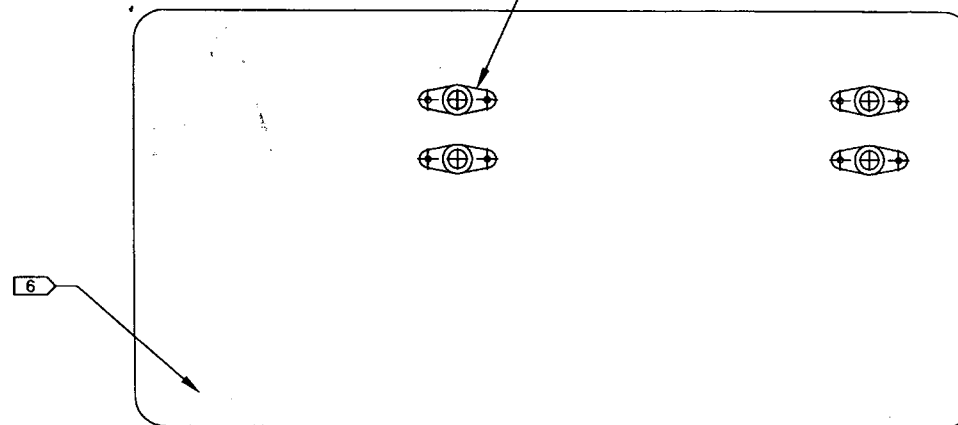
m134962

25

49
12

Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET

B
MS21059L4 NUTPLATE
MS20426AD3-3 RIVET, 2X
4 PL



D3220-1/2 DOUBLER

D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

SHOOT COPY
ACTION TO
DRAWING
CORRECTED COPY
SUBMIT TO APPROVEMENT
VENDOR/PRICE
DATE ORDER

147924 M05
1606-17

RELEASED
2009-09-09

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025		RF	09.07.08
A	NEW ISSUE		CP	03.10.16
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3220	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		DOUBLER	NTS	
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

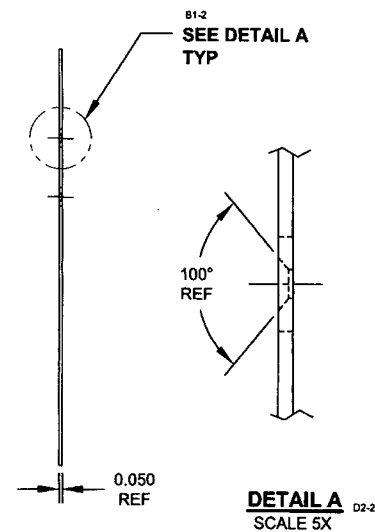
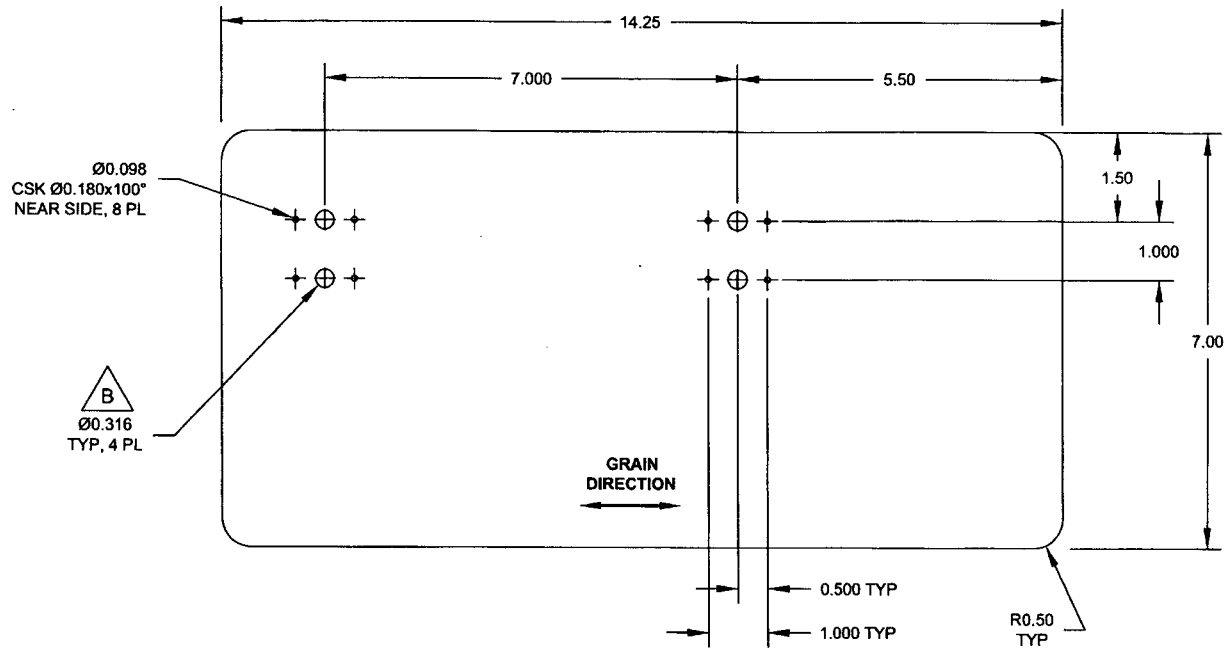
8 7 6 5 4 3 2 1

D

C

B

A



D3220-1 DOUBLER

RELEASED
2009-09-03



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3220	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

